

Date: Thursday, 10/08/2007 11:31:57 AM  
 User: Linda Lacelle

## Process Sheet

SPH-2

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STEP EXTRUSION
Jol. Number	: 34016 -2.	Part Number	: D2622120C
Est. mate Number	: 10058	Drawing Number	: D2622 REV C1
P.C. Number	: N/A	Project Number	: N/A
This Issue	: 16/08/2007 S.O. No. : N/A	Drawing Revision	: C1
Print Rev.	: NC	Material	: N/A
First Issue	: N/A Type : PURCHASED PARTS	Due Date	: 10/09/2007
Previous Run	: 32858	Qty:	42
Written By	: [Signature]		
Checked & Approved By	: [Signature]		
Comment	: Est. VA. 02.11.12 New Issue KJ/RF		

Additional Product



Seq. #: Machine Or Operation: Description:

1.0

PG

PURCHASING



Comment: PURCHASING

Issue P/O

1375

C/L 7/06/16

(110)

- a) Extrude as per Dwg D2622 Rev. C
- b) Material: 6061-T6 (QQ-A-200/8)
- c) Minimum yield tensile strength = 35 ksi
- d) Minimum ultimate tensile strength = 38 ksi
- e) Minimum elongation = 8%
- f) Order at 120" longg) Bon L Canada Inc. tool # 897123 Rev. A
- h) To be packed per DSK 066
- i) Pull test to ASTM standard B221 required.
- j) Material certification is required

2.0

D2622120CP

Extrusion



Comment: Qty: 1.0000 Each(s)/Unit Total: 110.0000 Each(s)

Extrusion

3.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive &amp; Inspect For Transit Damage

Ensure material certification is attached

C/L 7/4/25

(132)

4.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Inspect dimension per Dwg D2622

Check Pull test per Dwg D2622 for compliance page attached

Check hardness with Webster tester

0709-06

(132)

Form: rpro.ess



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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP EXTRUSION

Job Number: 34016

Part Number: D2622120C

Job Number



Seq. #:

Machine Or Operation:

Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WA

*7/19*

*SP*

*(42x)*

*(42)*

5.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*RD 07/10/11*

Job Completion



*IN 07.10.10*







DESIGN KE	DRAWN BY G	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D2622	REV. 0 PAGE 1 OF 1
DATE 02.09.11		TITLE STEP EXTRUSION	SCALE
A	96.11.29	NEW ISSUE	
B	97.12.12	CHANGE MATERIAL, ADD TOL. D5	
C	02.09.11	0.080 WAS 0.085; ADD PART & DE NO	
CI	02.10.11	MATERIAL CHANGE	

W/O: 34014

MANUFACTURED USING BON-L DIE # 897123 REV. A

MINIMUM TENSILE YIELD STRENGTH = 35 ksi  
MINIMUM ULTIMATE TENSILE STRENGTH = 38 ksi  
MINIMUM ELONGATION = 8%

6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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SHIPPING MANIFEST  
BORDEREAU D'EXPEDITION

EXONY

**SOLD TO/VENDU À**

BILL OF LADING NUMBER/N° DE CONNAISSÉMENT

UNIT UNITÉ	QUANTITY/D QUANTITÉ PRI
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$$\begin{array}{r} 43 \\ 43 \\ 43 \\ \hline 132 \end{array}$$

RIALS WILL BE ACCEPTED FOR CREDIT WITHOUT PERMISSION  
E MATERIEL NE SERA ACCEPTE POUR CREDIT SANS AUTORISATION

CUSTOMER  
CLIENT

TOTALS/TOTAUX

132





**BON L CANADA INC**500 EDWARD AVENUE  
RICHMOND HILL, ON L4C 4Y9**CERTIFICATE OF COMPLIANCE**

<b>Cert Date</b>	<b>Cert No</b>	<b>Sales Order</b>	<b>Page</b>
08/28/07	165105	82904	1
<b>Cust PO</b>	<b>B/L No</b>	<b>Lot</b>	<b>Date</b>
4375	00355495	82904010	8/28/07
<b>Sold To</b>	<b>Ship To</b>		
46024	46024		
DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7		DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7	

Item No	Part No	Item Description	Cust Part
1.000	DAA-897123-1	120" Mill 6061 T6	D2622

Gross Weight	578 KGS
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Net Qty	536 KG	132 PC	402 M	3 PKG
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Specification	Die Desc
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AMS-QQ-A-200/8 &amp; ASTM B221-00

**Mechanical Tests:**

Test No.	Tensile MPA / KSI	Yield MPA / KSI	%Elongation	Conductivity	Bend/Drift HREW
1	314.5 / 45.6	271.8 / 39.4	12.1	.0	95

**Chemical Analysis:**

SI	FE	CU	MN	MG	CR	NI	ZN	GA	V	TI	ZR	OTHER
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.67	.25	.29	.06	.91	.07	.000	.04	.000	.008	.02	.000	.00
.00	.00	.00	.00	.00	.00	.000	.00	.000	.000	.00	.000	.00
.00	.00	.00	.00	.00	.00	.000	.00	.000	.000	.00	.000	.00

This will certify that the material described herein has been inspected and tested in accordance with Bon L Canada's standard sampling and testing procedures or in accordance with the requirements of any specifications forming a part of the material description to the extent indicated herein. Data of chemical composition for the material and test results from samples representative of the material are set forth above hereof or in any attachments hereto. This information shows that the material meets the applicable requirements. Inspection and test records are maintained on file. This certificate shall be deemed apart of and subject to the terms and conditions of warranty set forth on the reverse side of our order acknowledgement form. No other warranties are applicable.

D. VanBakel, QA Manager Signed for Bon L Canada

